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RBW6405G04032-3G

Job Sheet 198008



Part No: RBW6405G04032-3G

Job Qty: 1 pcs

Part Name: AW139 Tail Rotor Duplex Bearing Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17721

Note: DWG RBW6405G04032-3G Rev.F IPP Rev. A 19.03.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	9/20/19		0.08	0.17	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	9/20/19		0.00	0.00	QC 5 - 10		DAS 40 SEP 3 0 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/20/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	9/20/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1650-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW6405G04032-3G-4 to RBW6405G04032-3G-3 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

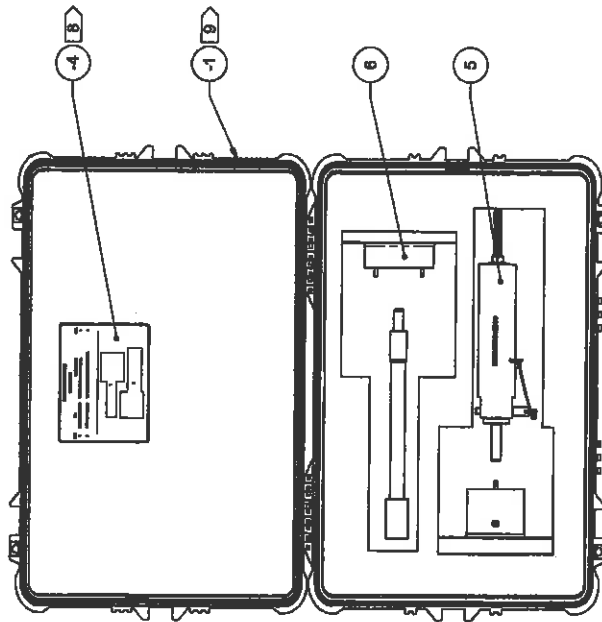
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1650-E	Case	1 Ea (1 ea)	100-Small Fab - 1	5 204620
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	100-Small Fab - 1	5021040
RBW6405G00631-3G	Tail Rotor Duplex Bearing Removal	1 pcs (1 ea)	100-Small Fab - 1	5217996
RBW6405G04032-3G-2	Bottom Foam	1 (1 ea)	100-Small Fab - 1	5204618
RBW6405G04032-3G-3	Top Foam	1 (1 ea)	100-Small Fab - 1	5204619
RBW6405G04032-3G-4	Content Placard	1 pcs (1 ea)	100-Small Fab - 1	5 200328
RBW6405G04132-3G	Tail Rotor Duplex Bearing Install	1 pcs (1 ea)	100-Small Fab - 1	5210227
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - 1	5206761

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	97524A032	4	161	0
	APP-1650-E	1	6	0
	RB41011	1	274	0
	RBW6405G00631-3G	1	0	0
	RBW6405G04032-3G-2	1	0	0
	RBW6405G04032-3G-3	1	0	0
	RBW6405G04032-3G-4	1	0	0
	RBW6405G04132-3G	1	0	0
Part Specifications				
Specifications could not be found.				

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6405G04032-3G-1	PACKAGING ASSY
-4	1	RBW6405G04032-3G-4	CONTENT PLACARD
5	1	RBW6405G04132-3G	T/R DUPLEX BEARING INSTALLATION
6	1	RBW6405G00631-3G	T/R DUPLEX BEARING REMOVAL
7	1	RB41011	DART PLACARD
8	4	McMaster #87524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" L.G.



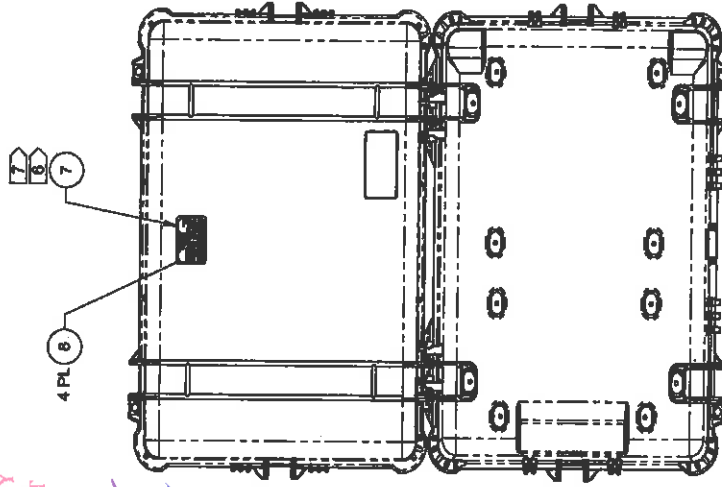
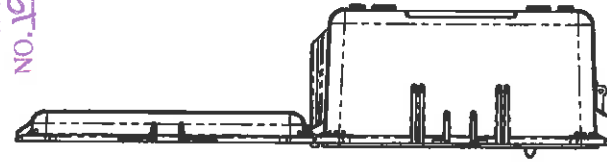
RBW6405G04032-3G AW139 T/R DUPLEX BEARING TOOL KIT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm .1"$
X.XX = $\pm 0.04"$ / $\pm 0.05"$
X.XXX = $\pm 0.005"$ / $\pm 0.006"$
X.XXXX = $\pm 0.0008"$ / $\pm 0.001"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) PARALLELISM: ENGRAVE THE TOOL PIN ON THE DART PLACARD WHERE INDICATED
- 7) IDENTIFICATION: ENGRAVE THE TOOL PIN ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINUM POP RIVETS
- 9) HOT GLUE THE CONTENT PLACARD ONTO THE TOP FOAM
- 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198008 MJS
190722



F	SEE OLD PDFs FOR OLDER REVs TEMPLATE UPDATE PER DART HBY STANDARDS ITEM -1 PACKAGING ASSY ADDED ITEM -4 CHANGED FOR ITEM 3 ITEM -5 CHANGED FOR ITEM 3 ITEM -6 CHANGED FOR ITEM 3 ITEM -7 CHANGED FOR ITEM 4 RIVETS FOR DART PLACARD ADDED ITEM -4 DIMENSION 0.00 CHANGED FOR 0.00 ITEMS -2 AND -3 CUTOUT CHANGED	19-617 VM
REV. DESCRIPTION	ECON # BY	
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	VM	TOOL PART # RBW6405G04032-3G
MFG. APPR.	VM	REV. F SHEET 1 OF 6
APPROVED	VM	TITLE AW139 T/R DUPLEX BEARING TOOL KIT
DATE	3/1/2018	SCALE NTS

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Cross tube ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Machining ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Engineering ☐ ☐ ☐ Supplier ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Quality ☐ ☐ ☐						Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition													
Completed By				Lead hand / Supervisor													
										QC / QA Coordinator							